



TOOL BIT SELECTION CHART

For 604SB - 612SB

Clamshell Lathes (For 2"-12" Pipe)

Note: The following chart covers only some of the available bits and prep configurations. Contact your TRI TOOL® DURABIT™ sales representative for application assistance or more information.

Prep Config.

37.5° Double Bevel



Machine Type

604 SB to 608 SB
610 SB to 612 SB

37.5° Right Hand



604 SB to 608 SB
610 SB to 612 SB

37.5° Left Hand



604 SB to 608 SB
610 SB to 612 SB

Config. for Sever Only

90° LH Sever (Cut away from tool)



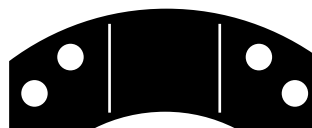
Machine Type

604 SB to 608 SB
610 SB to 612 SB

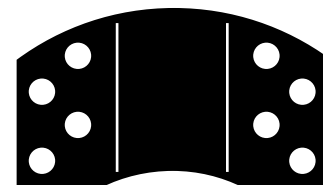
90° RH Sever (Cut close to tool)



604 SB to 608 SB
610 SB to 612 SB



P/N 08-0037 - Low Profile
Tool Block Module



P/N 08-0040 - Extended
Tool Block Module

Low Profile Blocks

<i>Sever Bit</i>	<i>Bevel Bit</i>
P/N 99-1643	P/N 99-1642
P/N 99-0986	P/N 99-0987

Extended tool Blocks

<i>Sever Bit</i>	<i>Bevel Bit</i>
P/N 99-0467	P/N 99-0466
P/N 99-0467	P/N 99-0466

P/N 99-1645	P/N 99-1644
P/N 99-1267	P/N 99-1266

P/N 99-1259	P/N 99-1258
P/N 99-1259	P/N 99-1258

P/N 99-1647	P/N 99-1646
P/N 99-1265	P/N 99-1264

P/N 99-1257	P/N 99-1256
P/N 99-1257	P/N 99-1256

<i>Leading Bit</i>	<i>Trailing Bit</i>
P/N 99-1638	P/N 99-1639
P/N 99-1596	P/N 99-1595

<i>Leading Bit</i>	<i>Trailing Bit</i>
P/N 99-0502	P/N 99-0501
P/N 99-0502	P/N 99-0501

P/N 99-1641	P/N 99-1640
P/N 99-1597	P/N 99-1598

P/N 99-1023	P/N 99-1022
P/N 99-1023	P/N 99-1022

Aluminum Pipe Pad Sets.

	604SB	606SB	608SB	610SB	612SB
2"	67-3038	n/a	n/a	n/a	n/a
3"	67-3060	n/a	n/a	n/a	n/a
4"	67-3028	67-3038	n/a	n/a	n/a
5"	n/a	67-3033	67-3009	n/a	n/a
6"	n/a	67-3028	67-3008	n/a	n/a
7"	n/a	n/a	67-3076	n/a	n/a
8"	n/a	n/a	67-3007	67-3010	n/a
10"	n/a	n/a	n/a	67-3093	67-3102
12"	n/a	n/a	n/a	n/a	67-3093

Part numbers are for standard sets of pads, fixed and adjustable. Individual pads are available.

DURABIT™ tool bits are available for all weld preps.



Square Bevel Compound "J" Prep Counterbore

To reorder bits call toll free 1-888-DURABIT

Common Accessories

- P/N 05-0116 - CBM2 Counterbore Module for 604 SB through 612 SB. Fits both tool block assemblies:
- P/N 99-2669 - 4:1 C/B Bit 1.375" long
- P/N 99-2670 - 4:1 C/B Bit 2.25" Long, Bbl Edge

Full support pad sets are available for thinwall pipe applications or stainless pad sets where bi-metal contamination is a concern.

WARNING: BE SAFETY CONSCIOUS!
Thoroughly read and understand the operator's manual before attempting to use this equipment.

Tool Block Maintenance Parts

<i>For Blocks</i>	<i>P/N 08-0037 Low P.</i>	<i>P/N 08-0040 Extd.</i>
Feed Nut	P/N 35-0176	P/N 35-0176
Sprocket Assy.	P/N 38-0050	P/N 38-0051
Tripper Assy.	P/N 14-0011	P/N 14-0011
Tripper Pin	P/N 32-0084	P/N 32-0084